



Dart Aerospace Ltd.
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D2739

Job Sheet 179091



Part No: D2739

Job Qty: 10 ea

Part Name: 350 I-Beam



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/13/18

Job Tracking No:

Due Date: 7/2/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D2739 REV E IPP Rev: C 02.11.28 Reformat KJ IPP Rev: D 06-03-21 As Per Rev C JLM IPP Rev: E 07-07-28 As per Rev D JLM Verified By: IPP Rev: F 10.11.02 as per rev E DD verf: EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	7/2/18	7/2/18	0.00	0.00	Start Up Skidtubes-2		
100	Skidtubes	10 pcs	7/2/18	7/2/18	0.00	5.41	Skidtubes-3		
120	HandFinish	10 pcs	7/2/18	7/2/18	0.00	0.83	HandFinish1		
130	QC	10 pcs	7/2/18	7/2/18	0.00	0.00	QC5		
140	Packaging	10 pcs	7/2/18	7/2/18	0.00	0.00	Packaging3-1		
150	QC21-SA	10 Ea	7/2/18	7/2/18	0.00	0.00	QC21		

Part Op 100 - 1-Cut D2600-5 to length as per Dwg D2739. 2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739
Descriptions: 3-Use uni-bit to open holes to finish size as per Dwg D2739. 4-Bevel Fwd end of extrusion and Deburr holes and ends.
140 - LOCATION : LG002

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-5-108	Extrusion I-Beam Thin	10 Ea (1 ea)	90-Start up Operation	B145248

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2600-5-108	10	69	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Web	78.760Inches $\pm$ 0.030	78.790 78.730		
2	Web	1.180Inches $\pm$ 0.010	1.190 1.170		
3	Web	3.150Inches $\pm$ 0.010	3.160 3.140		
4	Web	1.180Inches $\pm$ 0.010	1.190 1.170		
5	Web	0.250Inches $\pm$ 0.030	0.280 0.220		
6	Web	30.000Degrees + 0.500 - 5.000	30.500 25.000	Angle	

7	Web	1.250Inches ± 0.030	1.280 1.220
8	Web	7.880Inches ± 0.030	7.910 7.850
9	Web	10.070Inches ± 0.030	10.100 10.040
10	Web	12.990Inches ± 0.030	13.020 12.960
11	Web	16.540Inches ± 0.030	16.570 16.510
12	Web	20.870Inches ± 0.030	20.900 20.840
13	Web	25.200Inches ± 0.030	25.230 25.170
14	Web	29.530Inches ± 0.030	29.560 29.500
15	Web	32.650Inches ± 0.030	32.680 32.620
16	Web	33.860Inches ± 0.030	33.890 33.830
17	Web	35.350Inches ± 0.030	35.380 35.320
18	Web	38.280Inches ± 0.030	38.310 38.250
19	Web	41.350Inches ± 0.030	41.380 41.320
20	Web	44.350Inches ± 0.030	44.380 44.320
21	Web	47.400Inches ± 0.030	47.430 47.370
22	Web	50.150Inches ± 0.030	50.180 50.120
23	Web	52.900Inches ± 0.030	52.930 52.870
24	Web	64.060Inches ± 0.030	64.090 64.030
25	Web	70.270Inches ± 0.030	70.300 70.240
26	Web	73.020Inches ± 0.030	73.050 72.990
27	Web	75.770Inches ± 0.030	75.800 75.740
28	Web	56.150Inches ± 0.030	56.180 56.120

Plex 6/13/18 11:47 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					